

Work Order ID 71568



Page 1

Wednesday, July 06, 2011 1:19:36 PM

Item ID: D3560-041

Accepted



Setup Start



Revision ID:

-Stop



Item Name: Arm Weldment

Start Date: 7/6/2011 **Start Qty:** 4.00



Cust Item ID:

Required Date: 7/22/2011 **Req'd Qty:** 4.00



Customer:

Reference:

Approvals: **Process Plan:**

5

Date: 11/07/0

Date: _____ SPC (Y/N) _____

Date:

Run Start



Stop



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC8- Inspect parts - second check

0.00

RQ 11.7.27

4

QC

Memo

0.00

Quality Control

140



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad)
- 2- set up bracket and arm on jig
- 3- preheat bracket and arm with torch
- 4- clean before welding with brush
- 5- set up machine to 135 amps
- 6- weld across bottom and top ends
- 7- reheat with torch (65 deg C)
- 8- on one side weld from bottom to top half way
- 9- same for other side (half way)
- 10- from half way point weld the rest of the first side (ease off pedal near end) 11- same for remaining side (ease off pedal near end)

H 11.08.04

4 φ

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Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S woslos

(64)

-041

160



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

4 Ø Bev 08/04

170



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

4x Ø M 11/08/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 7/6/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

4/6/10 v/08/08

190



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1-Press bushing in D3560 arm per dwg D3562

Ep 5/08/10 ④

200



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S. w/ 08/08

+4 *041*

W/O:		WORK ORDER CHANGES					
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Required Date: 7/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: WA

0.00

Packaging

Memo

0.00

Packaging

*** STOCK IN STEP CELL***

WA 11-08-10.

220

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

CK 11/08/11

*11/08-11
(u)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, July 06, 2011 1:19:33 PM

Work Order ID: 71568



Parent Item: D3560-041



Parent Item Name: Arm Weldment

Start Date: 7/6/2011

Required Date: 7/22/2011

Comments: IPP Rev:A New Issue 07.05.24 EC
IPP rev B ECN 987 07.10.09 EC verified by: DD
IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Start Qty: 4.00

Start Qty: 4.00

Required Qty: 4.00

Required Qty: 4.00

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order:	71568
Description: Arm	Part Number:	D3560-1
Inspection Dwg: D3560	Rev: D	Page 1 of 1

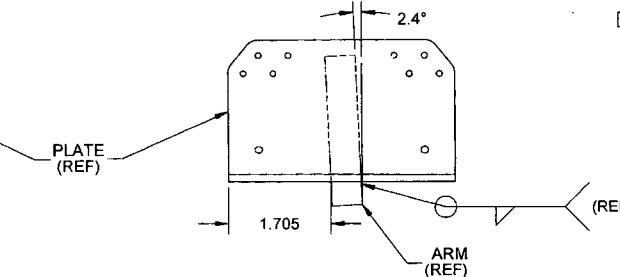
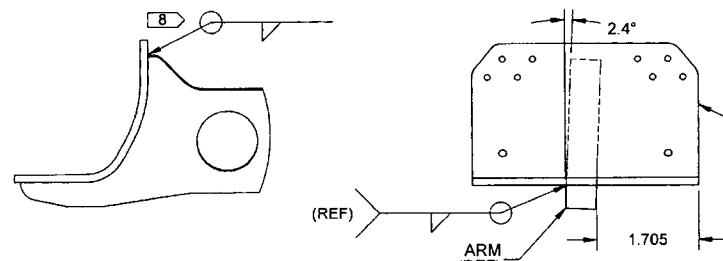
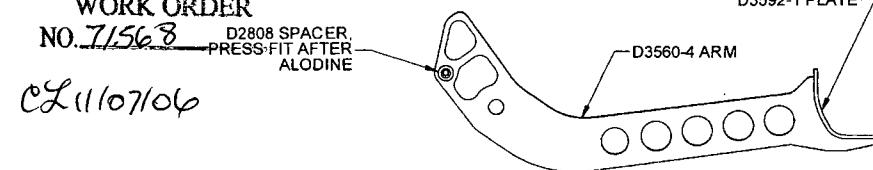
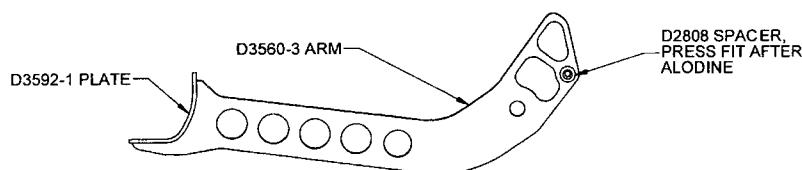
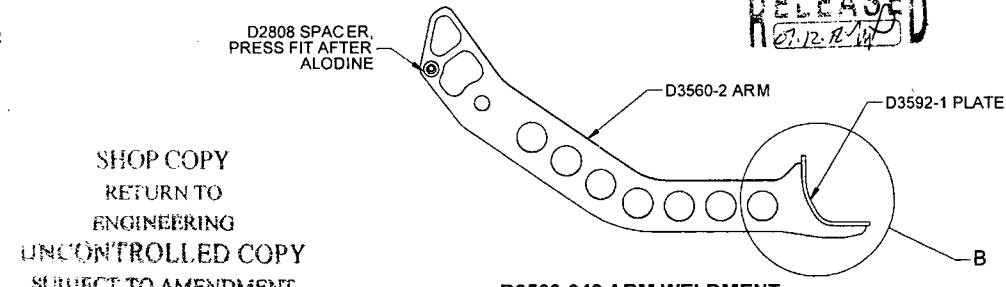
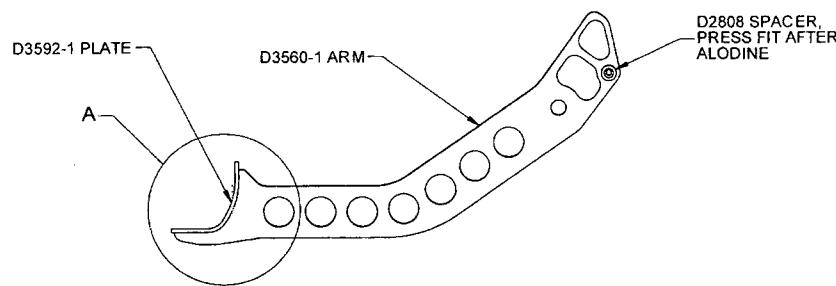
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>JL</u>	Audited by:	<u>RQ</u>	Prototype Approval:	N/A
Date:	11-07-06	Date:	11. 7 . 27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue P/O D3560-041	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	
C	08.07.24	Dwg Rev updated	KJ/DD	✓

RELEASED
07.12.2014



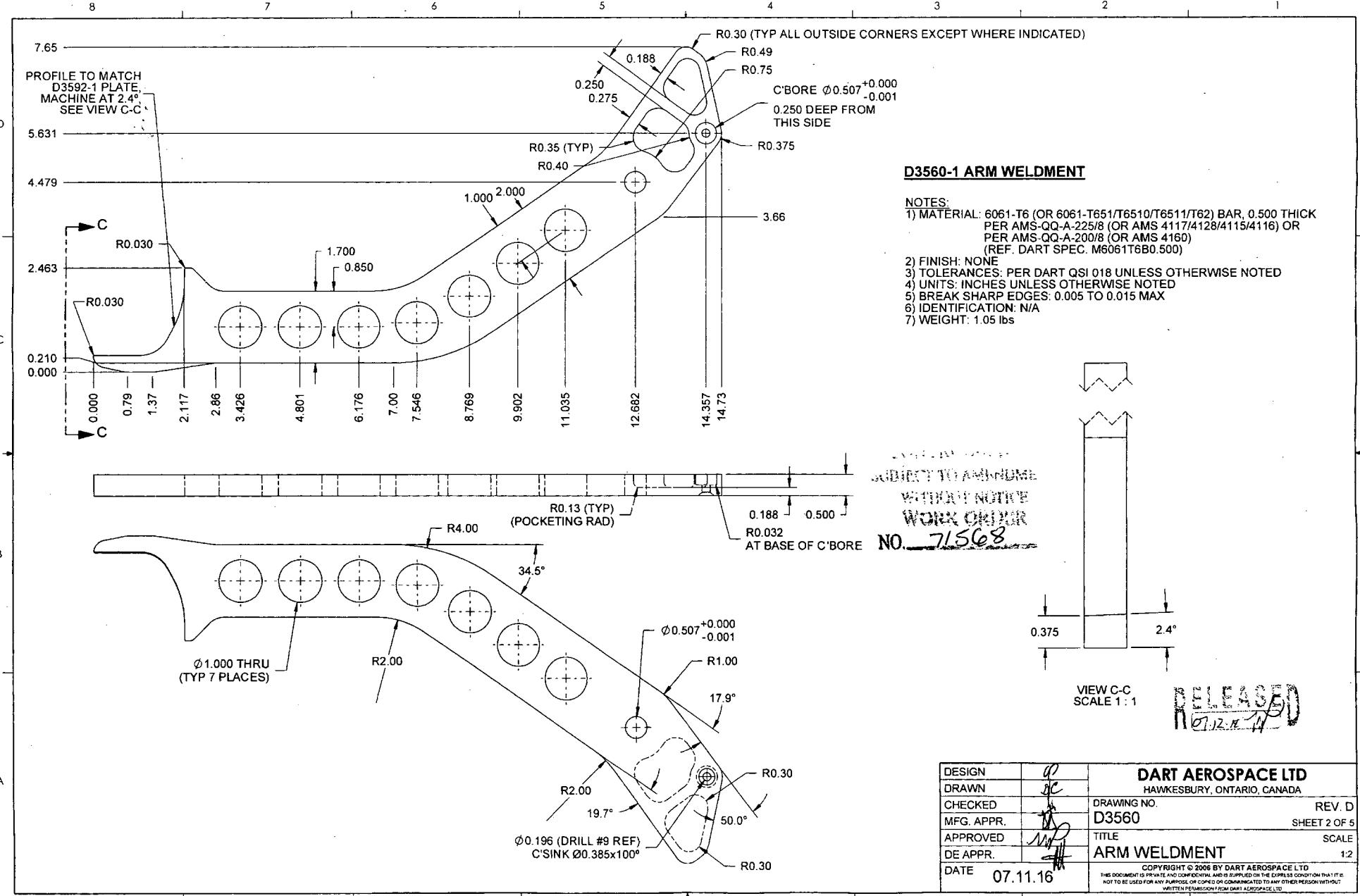
PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

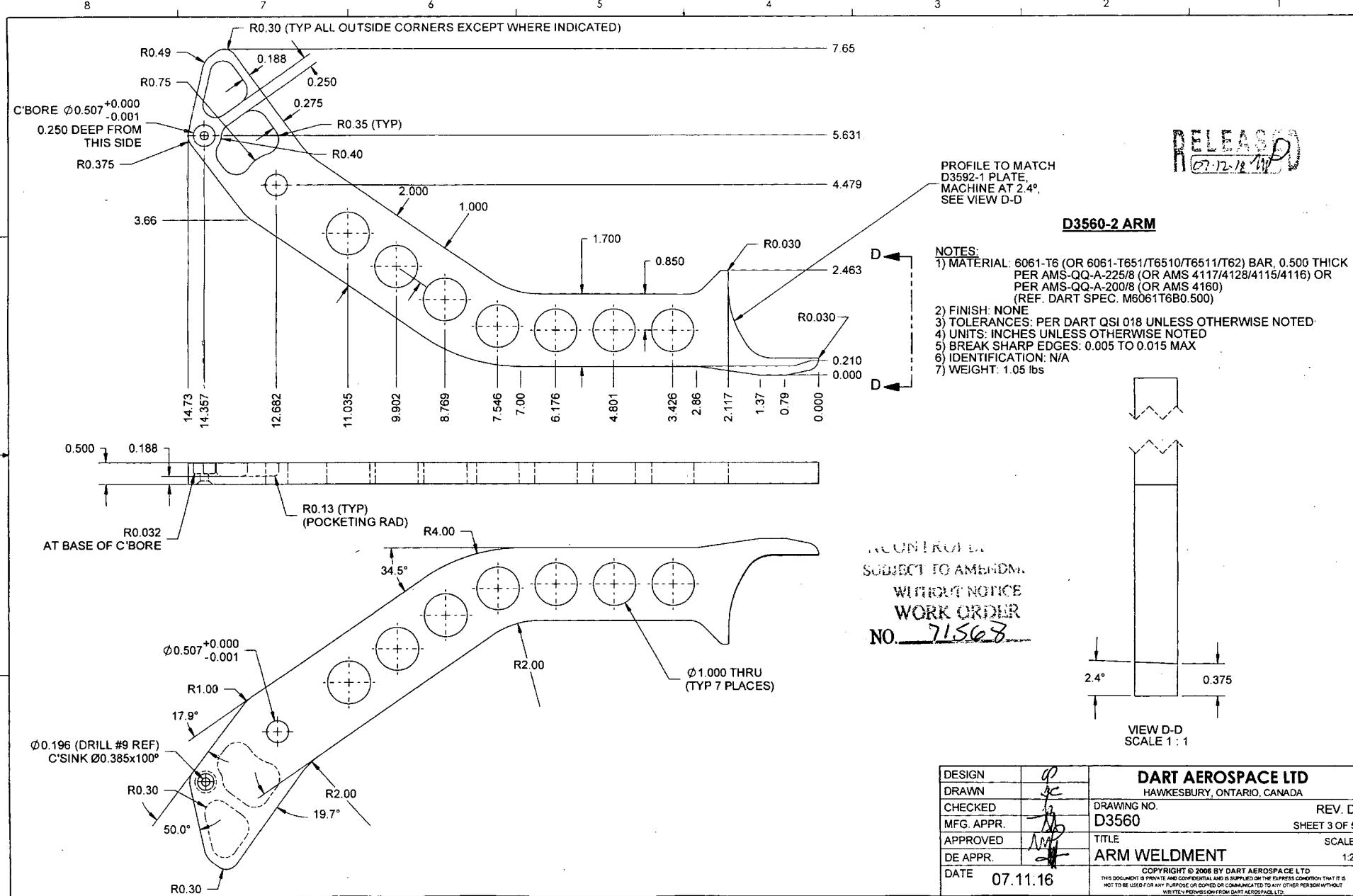
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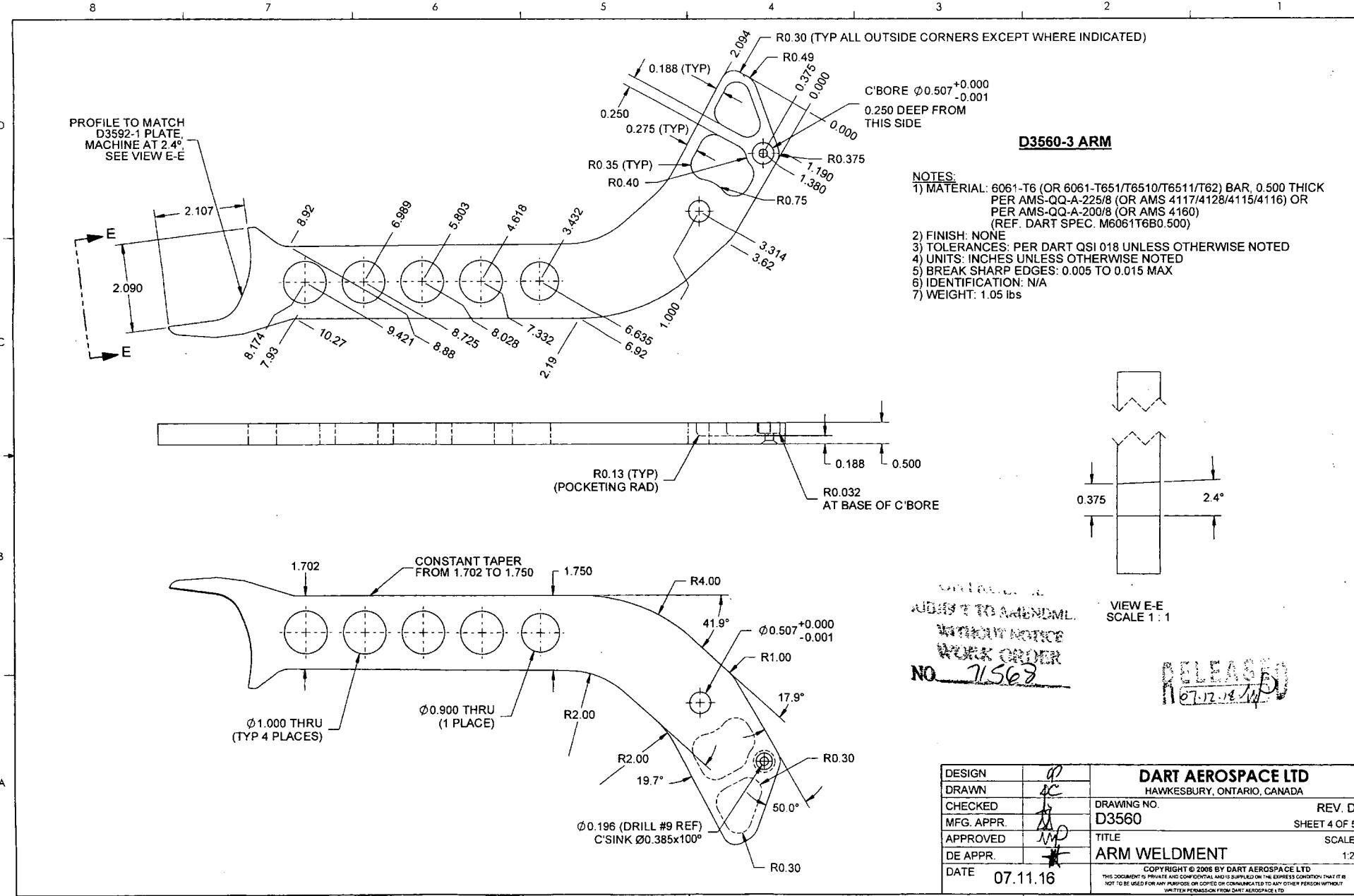
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.23 lbs (TYP)
- 8) WELDING: PER DART QSI 004

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN	160	DART AEROSPACE LTD	
DRAWN	KC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	15	DRAWING NO.	REV. D
MFG. APPR.	FE	D3560	SHEET 1 OF 5
APPROVED	FE	TITLE	SCALE
DE APPR.	SH	ARM WELDMENT	1:4
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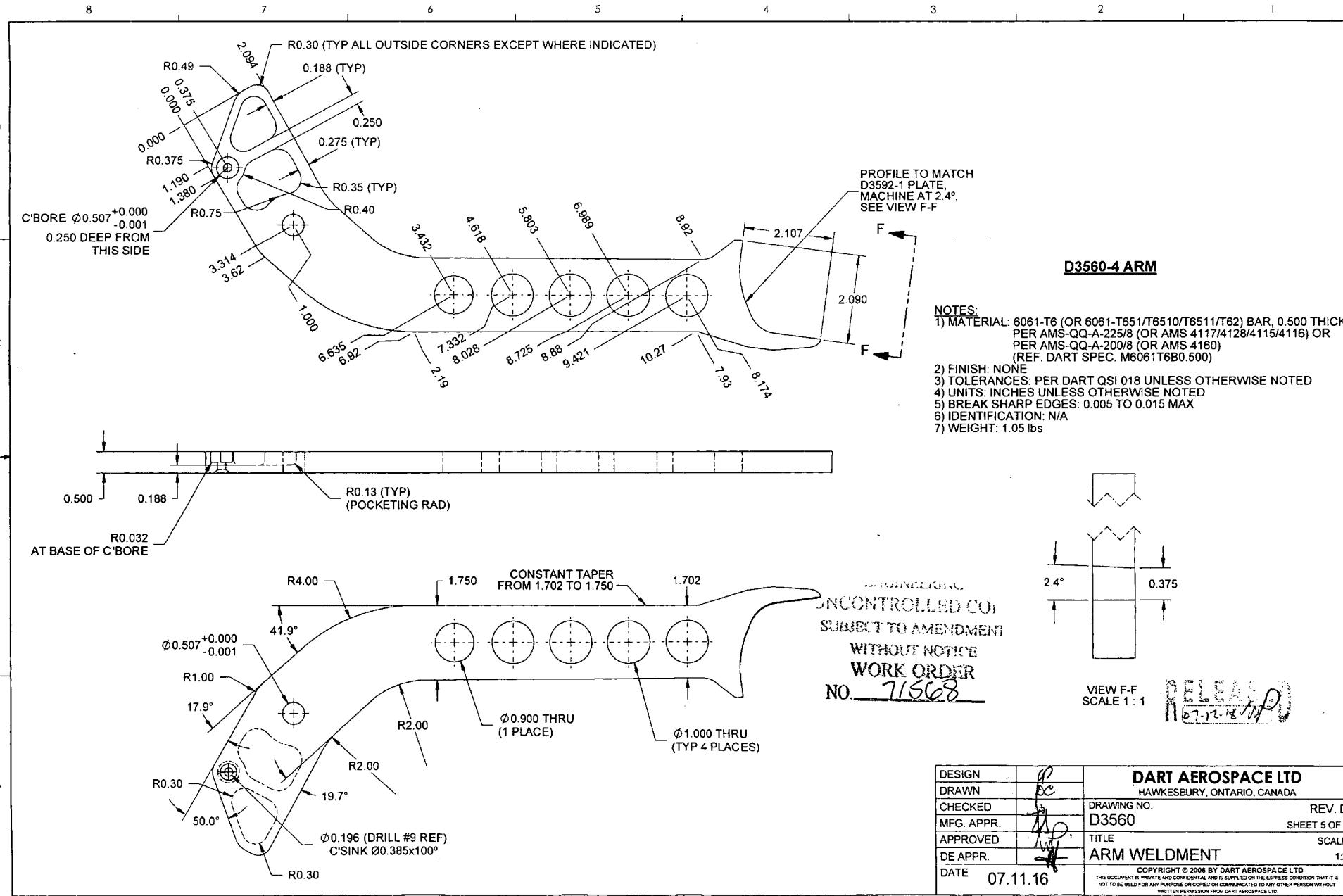


DESIGN	<i>DP</i>	DART AEROSPACE LTD	
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CHECKED	<i>TA</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>TJ</i>	D3560	SHEET 2 OF 5
APPROVED	<i>WJ</i>	TITLE	SCALE
DE APPR.	<i>WJ</i>	ARM WELDMENT 1:2	
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MFG. APPR.	<i>AT</i>	D3560 SHEET 4 OF 5	
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CHECKED	<i>SP</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>MP</i>	D3560	SHEET 5 OF
APPROVED	<i>WY</i>	TITLE	SCALE
DE APPR.	<i>SP</i>	ARM WELDMENT	
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